

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007351**Date Inspected:** 21-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Zhang Bao Len and Geng Wei	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006	Component:	OBG	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 14

SMAW welding of weld joint 032 located on SEG039*.

Welder is identified as Mr. Luo Xuan Ping (067610) ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-B-U2-FCM-1.

SMAW welding of weld joint 032 located on SEG039*.

Welder is identified as Mr. Hao Jian Xiang (067665) ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-B-U2-FCM-1

SMAW welding of weld joint 032 located on SEG039*.

Welder is identified as Mr. Qie Jian Zhou (067571) ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-T-2214-B-U2-FCM-1

SMAW welding of weld joint 017 located on SEG063*.

Welder is identified as Mr. Qie Jian Zhou (067571) ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-T-2211-B-U2-FCM.

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Bay 13

SMAW welding of weld joints 027~031 located on SEG046*.

Welder is identified as Mr. Sun Lingling (048047). ZPMC QC is identified as Mr. Geng Wei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2213-B-U2.

SMAW welding of weld joint 250 located on SSD16A-PP16.

Welder is identified as Mr. Zhou Jibo (055564). ZPMC QC is identified as Mr. Geng Wei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4c-F.

SMAW welding of weld joint 15 located on SEG043A.

Welder is identified as Mr. Yuan Wen Song (055491). ZPMC QC is identified as Mr. Geng Wei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4c-F.

Bay 19

FCAW welding of weld joints 002, 003, 051 and 052 on SB015-068.

Welder is identified as Mr. Sun Ruidong (062806). ZPMC QC is identified as Mr. Liu Fa Wen.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 045, 046, 057 and 058 on SB014-050.

Welder is identified as Mr. Xie Biwu (062787). ZPMC QC is identified as Mr. Liu Fa Wen.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

Back of Bay 14

SMAW welding of weld joint 020 located on SEG027B.

Welder is identified as Mr. Li Bin (069896). ZPMC QC is identified as Mr. Zhang Bao Len.

The welding variables recorded by QC appeared to comply with WPS-B-U2-FCM-1.

SMAW welding of weld joint 009 located on SEG027B.

Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Mr. Zhang Bao Len.

The welding variables recorded by QC appeared to comply with WPS-B-U2-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
